

Work Order ID 144268

Monday, April 11, 2016 9:30:21 AM

144268

Page 1

Item ID: D350-721-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: AS350/AS355 Heli-Utility-Basket™ Lightweight Short Version - Fits LH or RH
 Start Date: 4/11/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/15/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference: REWOREK AS PER RS1031

Approvals: Process Plan: *[Signature]* Date: 16-4-11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								

105

0.00

105

Large Fab

Large Fab

Memo

PULL FROM STOCK
D350-721-043 X1
B: 142920

REWORK AS PER RS1031
REMOVE D3348-1 X4
AND RELOCATE
GRIND WELDS FLUSH. ENSURE TUBING IS NOT GROUND THIN

0.00

1 *[Signature]* 16-4-11

115

QC5- Inspect part completeness to step on W/O

0.00

115

QC

Quality Control

Memo

0.00

DAS

9

9-89

① 16-04-20

DART aerospace		MADE IN CANADA	
PART	N/A	CHG	CHG003
P/N	D350-721-043	SIC	SH93-1
DESC	Heli-Utility-Basket, Lwt, Short	SIC	SR00600NY
LOT	B142920	SIC	
MODEL	AS350/355	SIC	
TC-APPROVAL #09-89		D2728-3	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	AGAINST DEPARTMENT/PROCESS						
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				
								Completed By
								Lead hand / Supervisor Approval Verification
								QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY						
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐					

Work Order ID 144268

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144268

Page 2

Item ID: D350-721-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AS350/AS355 Heli-Utility-Basket™ Lightweight Short Version - Fits LH or RH

Start Date: 4/11/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/15/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference: REWOREK AS PER RS1031

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125		0.00							DAS 24 9-89
125									
Large Fab	Memo	0.00							
Large Fab	REWELD BRACKETS AS PER DRWING D3326 & PER qsi004								
135	QC9- Inspect visual per QSI004- Fusion Welds	0.00							DAS 9 9-89
135									
QC	Memo	0.00							
Quality Control									
145		0.00							DAS 34 9-89
145									
Powdercoat	Memo	0.00							
Powder Coating	SCUFF AND REPOWERCOAT BASKET.								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
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OTHER : ☐																									

Work Order ID 144268***144268***

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Wednesday, April 20, 2016 3:53:09 PM

Item ID: D350-721-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AS350/AS355 Heli-Utility-Basket™ Lightweight Short Version - Fits LH or RH

Start Date: 4/11/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/15/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference: REWOREK AS PER RS1031

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155	QC3- Inspect Part Finish	0.00							
155									
QC	Memo	0.00							
Quality Control									
165		0.00							
165									
HandFinish	Memo	0.00							
Hand Finishing	REASSEMBLE BASKET								
175		0.00							
175									
Packaging	Memo	0.00							
Packaging	REPACKAGE UNDER NEW BATCH NUMBER NEW LABELS								
	HARDWARE KIT WAS USED FOR TESTING. REPLACE WITH NEW HARDWARE AND LUGS								
	RUBBER CUSHIONS ARE GOOD AND STILL WITH KIT (D2732-030)								

DAS
28 BAS
9-89 27
9-89

APR 21 2016

Sold

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

Work Order ID 144268***144268***

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Wednesday, April 20, 2016 3:53:09 PM

Item ID: D350-721-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AS350/AS355 Heli-Utility-Basket™ Lightweight Short Version - Fits LH or RH

Start Date: 4/11/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/15/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference: REWOREK AS PER RS1031

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
185	QC21- Final Inspection - Work Order Release	0.00							
185									
QC	Memo	0.00							
Quality Control									

APR 21 2016

MC

MF
16-4-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Picklist Print

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Wednesday, April 20, 2016 3:37:42 PM

Work Order ID: 144268

144268

Parent Item: D350-721-043

D350-721-043

Parent Item Name: AS350/AS355 Heli-Utility-Basket™ Lightweight Short Version - Fits LH or RH

Start Date: 4/11/2016

Required Date: 4/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A05.02.09New issueKJ/JLM
IPP Rev:B 08-05-14 now @ chg 002 as per ECN1187 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-12A		Purchased	No				Each	198.0000		2			
---------	--	-----------	----	--	--	--	------	----------	--	---	--	--	--

AN4-12A

Bolt

Location	Loc Qty	Loc Code
----------	---------	----------

FG	10	
----	----	--

120423	10	
--------	----	--

over003	125	
---------	-----	--

m134606	125	
---------	-----	--

ST344	63	
-------	----	--

m134180	63	
---------	----	--

AN4-14A		Purchased	No				Each	449.0000		4			
---------	--	-----------	----	--	--	--	------	----------	--	---	--	--	--

AN4-14A

Bolt

Location	Loc Qty	Loc Code
----------	---------	----------

FG	5	
----	---	--

122141	5	
--------	---	--

over003	250	
---------	-----	--

M134508	100	
---------	-----	--

M134573	150	
---------	-----	--

ST344	194	
-------	-----	--

M133998	194	
---------	-----	--

DAS
28
9-89

DAS
28
9-89
APR 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐						
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval				
Description Work Order Deviation			Disposition					
						Completed By		
						Lead hand / Supervisor Approval Verification		
						QC / QA Coordinator Approval		
Root Cause			FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐								

Picklist Print

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Wednesday, April 20, 2016 3:37:42 PM

Work Order ID: 144268

144268

Parent Item: D350-721-043

D350-721-043

Parent Item Name: AS350/AS355 Heli-Utility-Basket™ Lightweight Short Version - Fits LH or RH

Start Date: 4/11/2016

Required Date: 4/15/2016

Start Qty: 1.00

Required Qty: 1.00

AN4-15A Purchased No

Each 304.0000 8

AN4-15A

Bolt

**

DAS

6

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

GA

34

120449

34

ST343

270

m134606

270

Each 123.0000

3

**

DAS

6

9-89

Location

Loc Qty

Loc Code

FG

4

84136

4

ST521

29

115306

1

138049

28

ST525A

90

140536

70

141691

20

Each 165.0000

4

**

DAS

6

9-89

Location

Loc Qty

Loc Code

FG

8

109344

4

89045

4

ST521

157

141406

157

DAS

6

9-89

DAS

28

9-89

APR 21 2016

D2230-3 Manufactured No

D2230-3

Mounting Lug

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Description Work Order Deviation				Disposition					
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		OTHER : ☐							

Picklist Print

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Parent Item: D350-721-043

D350-721-043

Parent Item Name: AS350/AS355 Heli-Utility-Basket™ Lightweight Short Version - Fits LH or RH

Start Date: 4/11/2016

Required Date: 4/15/2016

Start Qty: 1.00

Required Qty: 1.00

D2732-030

Manufactured No

Each 15.0000

8

D2732-030

Rubber Cushion - 3"

**

already in kit

mf 16-4-20

68-6
L2
SAS

Location

Loc Qty

Loc Code

FG

10

135594

10

ST410

5

144013

5

Each

9.0000

**

D3338-1

Manufactured No

D3338-1

Mounting Lug

68-6
L2
SAS

Location

Loc Qty

Loc Code

ST527

9

127949

9

Each

31.0000

**

D3348-1

Manufactured No

D3348-1

Clevis

Location

Loc Qty

Loc Code

WA004

31

142945

11

144212

20

Each

1.0000

**

D3350-041

Manufactured No

D3350-041

Strut Assembly

Location

Loc Qty

Loc Code

ST356

1

142943

1

DAS
8
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28
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mf 15-4-21

-2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Picklist Print

Wednesday, April 20, 2016 3:37:42 PM

Work Order ID: 144268

144268

Parent Item: D350-721-043

D350-721-043

Parent Item Name: AS350/AS355 Heli-Utility-Basket™ Lightweight Short Version - Fits LH or RH

Start Date: 4/11/2016

Required Date: 4/15/2016

Start Qty: 1.00

Required Qty: 1.00

D3350-041 Manufactured No

Each 1.0000 2

D3350-041

**

144549

DAS 28 9-89

Strut Assembly
68-6
27
DAS

Location

Loc Qty

Loc Code

ST356

1

142943

1

D350-721-043 Manufactured No

Each 0.0000 1

D350-721-043

**

142920

DAS 28 9-89

AS350/AS355 Heli-Utility-Basket™ Lightweight Short Version - Fits LH or RH

MS2104214 Purchased No

Each 2,230.000 16

MS210421 4

**

DAS 28 9-89

Locknut

Location

Loc Qty

Loc Code

GA

288

m133769

288

OVER007

1500

m134509

500

m134606

1000

ST303

345

m134055

1

m134502

344

ST305

97

m130922

97

68-6
27
DAS

APR 21 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Picklist Print

Page 5

Wednesday, April 20, 2016 3:37:42 PM

Work Order ID: 144268

144268

Parent Item: D350-721-043

D350-721-043

Parent Item Name: AS350/AS355 Heli-Utility-Basket™ Lightweight Short Version - Fits LH or RH

Start Date: 4/11/2016

Required Date: 4/15/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

Each

3,173.000

28

NAS1149D0463.J

**

DAS
28
9-89

WASHER

68-6
27
DAS

Location

Loc Qty

Loc Code

GA	383
M129390	41
M132035	21
M134508	321
ST260a	1761
M134508	600
<u>M134573</u>	1161
ST263	41
M134039	41
ST269	988
M132317	100
M132677	888

28

DAS
28
9-89

APR 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Page 1

Monday, April 11, 2016 9:30:26 AM

Work Order ID: 144268

144268

Parent Item: D350-721-043

D350-721-043

Parent Item Name: AS350/AS355 Heli-Utility-Basket™ Lightweight Short Version - Fits LH or RH

Start Date: 4/11/2016

Required Date: 4/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP A05.02.09New issueKJ/JLM

IPP Rev:B 08-05-14 now @ chg 002 as per ECN1187 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3348-1

Manufactured

No

Each

11.0000

4

D3348-1

Clevis

Location

Loc Qty

Loc Code

WA004

11

142945

11

D350-721-043

Manufactured

No

Each

1.0000

D350-721-043

AS350/AS355 Heli-Utility-Basket™ Lightweight Short Version - Fits LH or RH

Location

Loc Qty

Loc Code

FG100

1

142921

1

1
142920 2#16-4-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER :																									

DART AEROSPACE LTD	Work Order:	144268
Description: Repair Scheme for NCR16-5701 mounting lugs installed incorrectly		
Drawing: D3326-041	Repair Scheme:	RS1031
Part No: D350-721-044	Page:	1 of 1
Batch No: B14290 & B14291	Qty:	

Step	Location	Procedure	By	Date	Qty
1	Finishing	Pull parts as per NCR16-5701 D350-721-043 B142920 & B142921	Cpl	16.4.11	1
2	Finishing	Remove all hardware from baskets. Lable parts to be reassembled per b# of each basket	Cpl	16.4.11	1
3	Large Fab / Baskets	Remove all D3348-1 qty x4 from D3326-041 basket base	Cpl	16.4.11	1
4	Large Fab / Baskets	Grind welds flush. Enure that tuping is not ground thin.			1
5	Quality	QC5 verfy work to ensure that the material is not to thin	PD	16.04.11	(1)
6	Large Fab / Baskets	Pull D3348-1 qty x4 B <u>142945</u>	Cpl	16.4.11	1
7	Large Fab / Baskets	Re weld as per Drawing D3326 & per QSI004 D3348-1 in correct location A/RN/A 4130 Steel Rod <u>127925</u>	Cpl	16.4.11	1
8	Quality	QC 9 & 5 and perform a trial fit to ensure that D3348-1 are in correct locations	PD	16.04.11	(1)
9	Finishing	Suff all basket base	DAS	16.04.11	(1)
10		Re powder coat as per QSI004 Powder Coat <u>M134371</u> Start time <u>2:15</u> Oven temp <u>400°</u> Finish time <u>2:45</u>	34 9-89 234	16.04.11	(1)
11		QC3 inspect Powder coat finish	DAS	16.04.11	11
12	Finishing	Re assemble basket as per drawing List all parts that need replacing	34 9-89	16.04.11	41
13	Quality	QC5 inspect assembly	DAS	16.04.11	1
14	Stores	Put kit back into baskets	27	MAY 07 2016	
15	Quality	QC4 Ensure that correct kit is with basket Verify al labels are correct	9-89 SMB	16/4/20	1
16	Stores	Identfy & stock	MJS	16.04.20	
17	Quality	QC21	J		

Rev	Date	Change Description	Prepared	Checked	Approved
A	2016.04.08	New Issue	ED	PD	JP

New parts added:

(2x) D2931 / M 86435 (bumpers)

(2x) VAS1149DN 8325 / M134180 (washer)

16.05.16

Picklist Print

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Page 9

Work Order ID: 142920

142920

Parent Item: D350-721-043

D350-721-043

Parent Item Name: Lightweight Heli-Utility-Basket™ Short Version (Fits LH or RH)

Start Date: 3/14/2016

Required Date: 4/22/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

120

Each

2,041.000

2

2

DAS

NAS1149DN832.J

Washer

**

6
8-89

Location

Loc Qty

Loc Code

CA

84

M129499

84

ST260a

1500

M134180

1500

ST263

457

M131697

457

NAS1149DN949J

Purchased

No

120

Each

230.0000

24

24

NAS1149DN949.J

Washer

**

DAS
6
8-89

Location

Loc Qty

Loc Code

ST260a

100

m133483

100

ST265

130

m128995

30

m133234

100

AN4-12A

Purchased

No

150

Each

141.0000

2

2

AN4-12A

Bolt

**

DAS
6
8-89

DAS
28
8-89

MAR 31 2016

Location

Loc Qty

Loc Code

FG

10

120423

10

ST344

131

m133990

31

m134180

100

DAS
27
8-89

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Work Order ID: 142920

142920

Parent Item: D350-721-043

D350-721-043

Parent Item Name: Lightweight Heli-Utility-Basket™ Short Version (Fits LH or RH)

Start Date: 3/14/2016

Required Date: 4/22/2016

Start Qty: 1.00

Required Qty: 1.00

AN4-14A

Purchased

No

150

Each

563.0000

4

4

AN4-14A

Bolt

Location

Loc Qty

Loc Code

FG

5

122141

5

over003

500

M133998

500

ST344

58

M133316

15

M133769

43

DAS
6
9-89

DAS
28
9-89

AN4-15A

Purchased

No

150

Each

335.0000

8

8

AN4-15A

Bolt

Location

Loc Qty

Loc Code

GA

40

120449

40

over003

200

m134370

200

ST343

95

m134055

95

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

MAR 31 2016

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Shop Packet Print

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Picklist Print

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Page 11

Work Order ID: 142920

142920

Parent Item: D350-721-043

D350-721-043

Parent Item Name: Lightweight Heli-Utility-Basket™ Short Version (Fits LH or RH)

Start Date: 3/14/2016

Required Date: 4/22/2016

Start Qty: 1.00

Required Qty: 1.00

D2230-1

Manufactured No

150

Each

166.0000

3

3

DAS

DAS

D2230-1

Mounting Lug

**

6

28

9-89

9-89

Location

Loc Qty

Loc Code

FG

4

84136

4

ST521

42

115306

1

134015

3

138049

38

ST525A

50

141691

50

ST546A

70

140536

70

D2230-3

Manufactured No

150

Each

103.0000

4

D2230-3

Mounting Lug

**

DAS

28

9-89

Location

Loc Qty

Loc Code

FG

8

109344

4

89045

4

ST521

95

132403

4

140537

91

BAS
27
9-89

BAS
27
9-89

3

4

141406

MAR 31 2016

DAS
6
9-89

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Picklist Print

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Page 12

Work Order ID: 142920

142920

Parent Item: D350-721-043

D350-721-043

Parent Item Name: Lightweight Heli-Utility-Basket™ Short Version (Fits LH or RH)

Start Date: 3/14/2016

Required Date: 4/22/2016

Start Qty: 1.00

Required Qty: 1.00

D2732-030

Manufactured No

150

Each

104.0000

8

8

D2732-030

Rubber Cushion, 3"

**

DAS

6

DAS

28

9-89

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

FG

22

135594

22

ST410

82

140707

2

142155

80

D3338-1

Manufactured No

150

Each

14.0000

1

1

D3338-1

Mounting Lug

**

DAS

28

DAS

6

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

ST527

14

127949

14

D3350-041

Manufactured No

150

Each

6.0000

2

2

D3350-041

Strut Assembly

**

DAS

28

DAS

6

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

ST356

6

132503

2

84318

2

86105

2

MS21042L5

Purchased No

150

Each

445.0000

4

4

MS21042L5

Nut

**

DAS

6

9-89

DAS

27

9-89

Location

Loc Qty

Loc Code

GA

146

m127813

146

ST303

299

m134055

299

MAR 31 2016

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Picklist Print

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Work Order ID: 142920

142920

Parent Item: D350-721-043

D350-721-043

Parent Item Name: Lightweight Heli-Utility-Basket™ Short Version (Fits LH or RH)

Start Date: 3/14/2016

Required Date: 4/22/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

150

Each

3,623.000

28 28

NAS1149D0463.1

WASHER

**

DAS
28
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

237

M129390

41

M132035

196

ST263

2398

M134039

2398

28

ST269

988

M132317

100

M132677

888

MS21042L4

Purchased

No

160

Each

1,791.000

16 16

MS21042L 4

Locknut

**

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

37

m133363

37

GA

447

m133769

447

ST303

1210

4

m134055

1210

16

ST305

97

m130922

97

MAR 31 2016
DAS
28
9-89

Friday, March 11, 2016 3:02:44 PM

Shop Packet Print

Page 13

6.0 PARTS LIST

Qty -011	Qty -041	Qty -043	Qty -045	Qty -046	PART NUMBER	DESCRIPTION
X					D350-721-011	BASKET CLAMP KIT
	X				D350-721-041	LIGHTWEIGHT HELI- UTILITY-BASKET™
		X			D350-721-043	LIGHTWEIGHT HELI-UTILITY-BASKET™, SHORT VERSION
			X		D350-721-045	MAINTENANCE STEP, LH
				X	D350-721-046	MAINTENANCE STEP, RH
	1				D3324-041	BASKET BASE ASSEMBLY
	1				D3325-041	BASKET LID ASSEMBLY
		1			D3326-041	BASKET BASE ASSEMBLY
		1			D3327-041	BASKET LID ASSEMBLY
	2	2			D2022-101	SPACER
3	3	3			D2230-1	LUG
4	4	4			D2230-3	CLAMP
	1	1			D2332-041	PROP ASSEMBLY
	1	1			D2530	HANDLE ASSEMBLY
	2	2			D2535	SPRING
	2	2			D2537	BUSHING
8	8	8			D2732-030	RUBBER CUSHION
	2	2			D2931	BUMPER
	1	1			D3338-1	LUG
	2	2			D3350-041	STRUT
	1	1			D3351-1	LABEL
			1	1	D3436-041	CLAMP
			1		D3436-043	LH STEP
				1	D3436-044	RH STEP
	2	2			AN3-16A	BOLT
	2	2			AN4-7A	BOLT
	2	2			AN4-12A	BOLT
	4	4			AN4-14A	BOLT
8	8	8			AN4-15A	BOLT
			4	4	AN4-16A	BOLT
	1	1			AN4-20A	BOLT
	1	1			AN4-22A	BOLT
	4	4			AN5-17A	BOLT
			8	8	AN960-416	WASHER
16	30	30			AN960JD416	WASHER
	2	2			AN960JD416L	WASHER
	4	4			AN960JD516	WASHER
	2	2			AN960JD8	WASHER
	4	4			AN970-4	WASHER
			4	4	MS20365-428	NUT
	2	2			MS20600AD4W3	RIVET
	2	2			MS21042L3	NUT (OR MS21042-3)
8	18	18			MS21042L4	NUT (OR MS21042-4)
	4	4			MS21042L5	NUT (OR MS21042-5)

Work Order ID 144268

Monday, April 11, 2016 9:30:21 AM

144268

Page 1

Item ID: D350-721-043 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: AS350/AS355 Heli-Utility-Basket™ Lightweight Short Version - Fits LH or RH

Start Date: 4/11/2016 Start Qty: 1.00 ** Cust Item ID:

Required Date: 4/15/2016 Req'd Qty: 1.00 ** Customer:

Reference: REWOREK AS PER RS1031

Approvals: Process Plan: [Signature] Date: 16-4-11 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev N/A								

105

0.00

105

Large Fab

Large Fab

Memo

0.00

PULL FROM STOCK
D350-721-043 X1
B: 142920

REWORK AS PER RS1031
REMOVE D3348-1 X4
AND RELOCATE
GRIND WELDS FLUSH. ENSURE TUBING IS NOT GROUND THIN

1 [Signature] 16-4-11

115

QC5- Inspect part completeness to step on W/O 0.00

115

QC

Quality Control

Memo

0.00

0 16-04-20 DAS
9
980

DART aerospace		1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7 TEL.: 1-613-632-5200 www.dartaero.com	
PATENT	N/A		
P/N	D350-721-043	CHG	CHG003
DESC.	Heli-Utility-Basket, Lwt, Short	STC	SH93-1
LOT	B142920	STC	SR00600NY
MODEL	AS350/355	STC	